

Work Order ID 105586

105586

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August-08-13 9:23:08 AM

Item ID: D2702-1

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Arm

Start Date: 8/08/13

Start Qty: 3.00

3

Cust Item ID:

Required Date: 8/08/13

Req'd Qty: 3.00

3

Customer:

Reference: repowdercoat

- Rework

Run Start

NR1

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2702

Rev B

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

PUKLL FROM STOCK:
3 X D2702-1 B11342
STRIP COMPLETELY
RE-ALODINE

3 7/8 13.8.9

3 7/8 13.8.9

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

3 x m/f 13/08/13

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Item ID: D2702-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Arm
 Start Date: 8/08/13 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 8/08/13 Req'd Qty: 3.00 *3* Customer:
 Reference: repowdercoat

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	Black Sander (Ref: 4.3.5.7) per QSI005 4.3 <i>white</i> Memo REPOWDER COAT WHITE PER QSI005	0.00 0.00							<i>3x m/f 13/08/14</i>
	START TIME: <i>8:30</i> FINISH TIME: <i>4:00</i> OVEN TEMPERATURE:								
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>Bx p H 13/08/14</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>87230</i> Memo RE-IDENTIFY USING NEW B/N	0.00 0.00							<i>3x SP 13-8-15</i>

M126125

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Item ID: D2702-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Arm

Start Date: 8/08/13 Start Qty: 3.00

3

Cust Item ID:

Required Date: 8/08/13 Req'd Qty: 3.00

3

Customer:

Reference: repowdercoat

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

13/8/2013
MCS 13-08-15

Picklist Print

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Work Order ID: 105586

Parent Item: D2702-1

Start Date: 8/08/13

Required Date: 8/08/13

Parent Item Name: Step Arm

Start Qty: 3.00

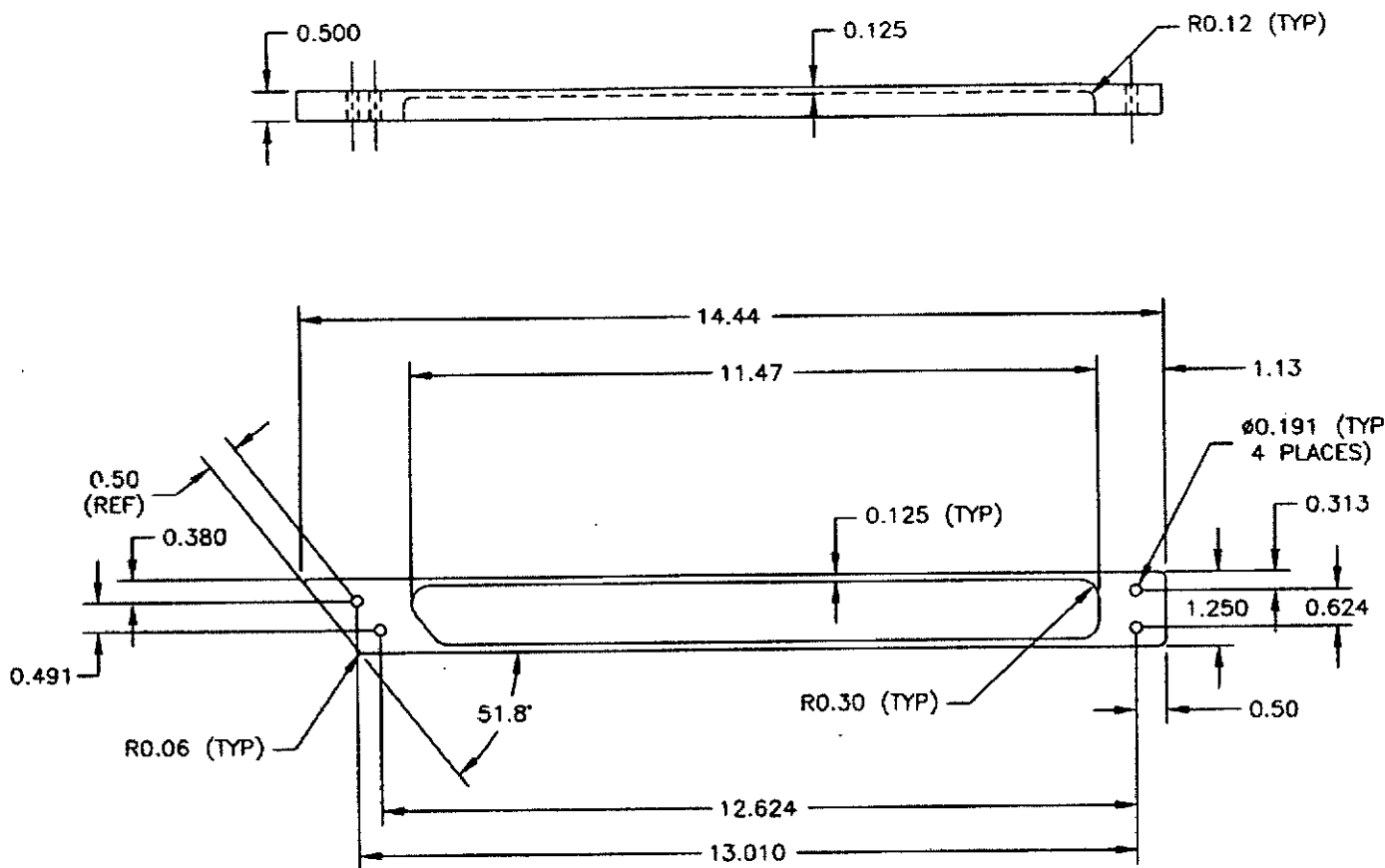
Required Qty: 3.00

Comments: IPP C00.11.01Removed P/O for Powder Coat - in house processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2702-1 Step Arm		Manufactured	No				Each	0.0000		3		11/3/12	

DART**RELEASED**
99.11.02 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
VE	VE		
CHECKED	APPROVED	DRAWING NO.	REV. B
CP	SK	D2702	SHEET 1 OF 1
DATE	TITLE		SCALE
99.10.20	STEP ARM		1:3
A	97.09.10	NEW ISSUE	
B	99.10.20	UPDATE TOLERANCE AND FINISH	



D2702-1 LEFT HAND (SHOWN)
D2702-2 RIGHT HAND (OPPOSITE)

W/O 105586

NOTE: DEBURR ALL EDGES R0.030-R0.060
MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-225/8 OR QQ-A-200/8 OR QQ-A-250/11)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

